

02/06/2009 11:29:28 AM

Process Sheet

CU-DAR001 Dart Helicopters Services	Drawing Name	: 350 BASKET BASE (SHORT)
48310A		
ate Number : 10209		
P.O. Number :	Part Number	: D3265041
This Issue : 02/06/2009 S.O. No. :	Drawing Number	: D3265 REVC
Prsht Rev. : NC	Project Number	: N/A
First Issue : // Type : LARGE FAB ASSY	Drawing Revision	: C
Previous Run : 47269A	Material	:
Written By :	Due Date	: 10/06/2009 Qty: 1 Um: Each
Checked & Approved By : <u>JLD 09-06-02</u>		
Comment : Est Rev:C Re-Format 05-11-03 JLM		
Est Rev:D 08-09-10 revC as per dwg (ecn 08-524) DD verified by:EC		
Est rev E 09.03.23 updated per B46309A EC verified by:DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

✓ 1.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
-------	----------------	---------------------------



Comment: Qty.: 19.2150 f(s)/Unit Total : 19.2150 f(s)
 3/4" x 3/4" x 0.065" wall 304/316 SS tubing.
 (M304TS0.750W.065)
 Batch: 112051

✓ 2.0	D3826041	Rib / Gusset Assembly
-------	----------	-----------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Rib / Gusset Assembly B48431

✓ 3.0	D22323	Basket Hinge
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Pick:

Qty Part Number	Description	Batch
2 D2232-3	Hinge bracket	<u>B46949</u>

✓ 4.0	D22351	Basket Rib
-------	--------	------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Basket Rib B48451

SAD 09-06-18 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 02/06/2009 11:29:28 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 BASKET BASE (SHORT)

Job Number: 48310A

Part Number: D3265041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D23273

Spacer Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2327-3

Bushing

B44274

SAD 09-06-18 ①

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2581

Mounting Bracket

B47264

SAD 09-06-18 ①

7.0

D34425

Shim



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3442-5

Shim

B33282

SAD 09-06-18 ①

8.0

M304EX07516F

Expanded Metal Flat SS



Comment: Qty.: 26.0000 sf(s)/Unit Total : 26.0000 sf(s)

Pick:

Qty Part Number

Description

Batch

26sf

M304EX0.75-16F

Expanded Metal

M111956

SAD 09-06-18 ①

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-CUT (3) D2235-1 FROM D3166-1

SAD 09-06-18 ①

2-Drill hole in D3265-3 as per Dwg D3265

SAD 09-06-18 ①

3-Remove all markings from material

SAD 09-06-18 ①

4-Weld as per Dwg D3265 using Welding Table and corner JigDeburr as required

Cpl 09-06-22

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 02/06/2009 11:29:28 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 BASKET BASE (SHORT)

Job Number: 48310A

Part Number: D3265041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09.06.23

11.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

5 09/06/23 (H)

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

1ST COAT:

START TIME:

10:15am

OVEN TEMPERATURE:

400°C

FINISH TIME:

10:45am

2ND COAT:

START TIME:

11:00am

OVEN TEMPERATURE:

400°C

FINISH TIME:

11:30am

20 09-06-23

(H)

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 09-06-24 (H)

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: Small Medium Fab

Seal support gusset seam with White Sikaflex-291

Batch:

M111537

Expiry date:

10/01

BR 09-20-24 (H)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

509/06/24 (H)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 02/06/2009 11:29:28 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 BASKET BASE (SHORT)

Job Number: 48310A

Part Number: D3265041

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPP 48310

9/6/24

10

SP

17.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/24

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 09.06.24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	PART NUMBER	DESCRIPTION
X	D3265-041	BASKET ASSEMBLY
2	D2232-3	HINGE PLATE
4	D2235-1	RIB
4	D2325	SUPPORT GUSSET
2	D2327-3	BUSHING
2	D2581	MOUNTING BRACKET
2	D3265-1	RIB
2	D3265-3	RIB
2	D3265-5	RIB
2	D3442-5	SHIM

NO. 148301
 WORK ORDER
 WITHOUT NOTICE
 UNCONTROLLED COPY
 ENGINEERING
 RETURN TO
 SHOP COPY

DEO ATTACHED

RELEASED
 06-09-01/11/12

NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004

C	DRAWING UPDATED TO CURRENT STANDARDS. SHT 4 ADDED. RIB MATERIAL WAS 0.060 THICK. SHT 2 ZONE D5 25.63 DIMENSION WAS 27.63.	AJS	08.08.14
B	INCORPORATED A1. ADD SHIM UNDER HINGES. ADD HOLES FOR SPLIT LID BASKETS.	PH	05.06.08
A	NEW ISSUE	CP	04.02.02
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3265	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.08.14	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

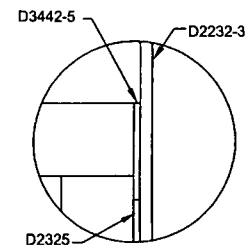
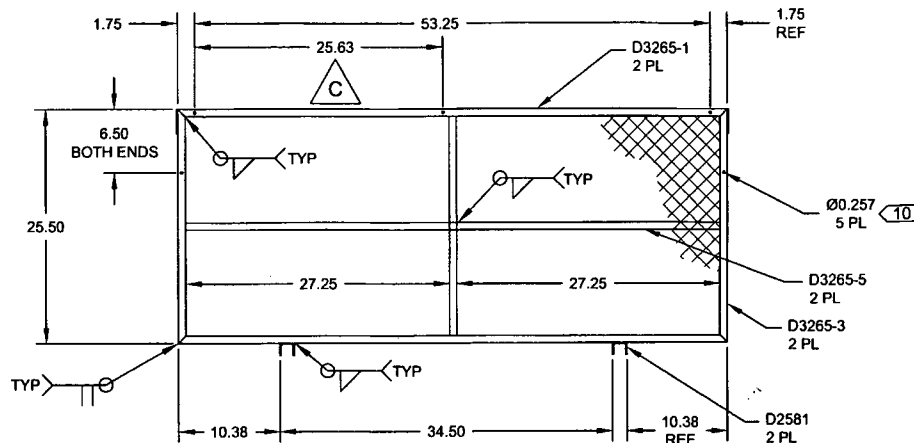
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

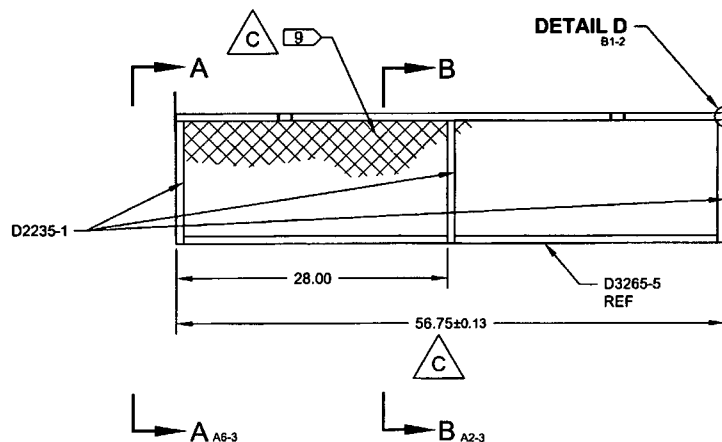
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

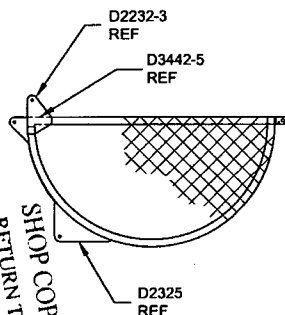
NOTE: Date & initial all entries



DETAIL D
C4-2
(BOTH ENDS)
SCALE 10X



D3265-041 BASKET BASE ASSEMBLY



BASE ASSEMBLY NOTES:

- 1) FRAME MATERIAL: SEE SHEET 1
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) SKIN INSIDE SURFACE OF BASKET WITH EXPANDED STEEL MESH.
TACK WELD EACH END OF STRAND TO FRAME.
- 10) DRILL WHEN ASSEMBLING WITH D3267-041/-043 LID ONLY.

DEO ATTACHED
RELEASED

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3265	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.08.14	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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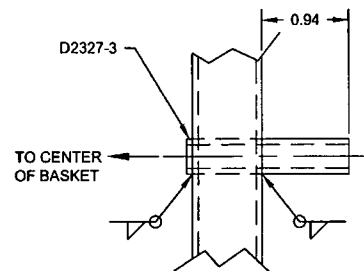
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

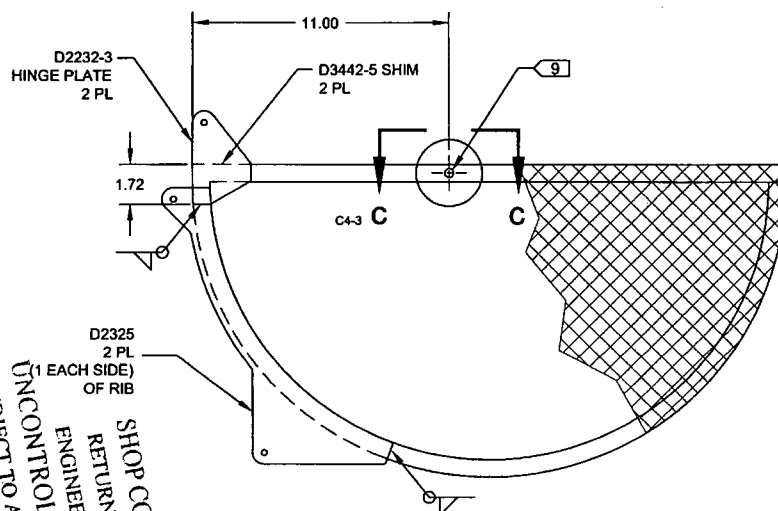
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

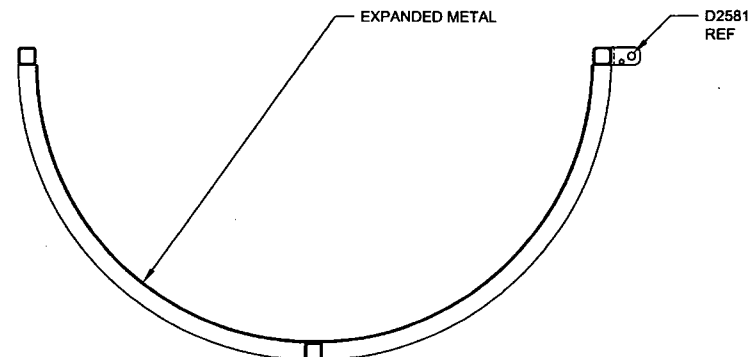
NOTE: Date & initial all entries



VIEW C-C B7-3
2 PL
SCALE 4X
ROTATED 90° CCW



SECTION A-A A5-2
2 PL
(BOTH END RIBS)



SECTION B-B A4-2
2 PL
(BOTH CENTER RIBS)

NO. 142304
B
WORK ORDER
A
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SUBJECT TO AMENDMENT
WITHOUT NOTICE

NOTES:

- 1) MATERIAL: SEE SHEET 1
- 2) FINISH: SEE SHEET 1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DRILL 3/8 HOLE AND INSTALL D2327-3 USING CLOSEST SPACE IN EXPANDED METAL FOR HOLE LOCATION BOTH ENDS

DEO ATTACHED
RELEASED
08-09-04/14

DESIGN	OS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A	DRAWING NO.	REV. C
MFG. APPR.	A	D3265	SHEET 3 OF 4
APPROVED	A	TITLE	SCALE
DE APPR.	A	BASKET BASE ASSEMBLY (350)	NTS
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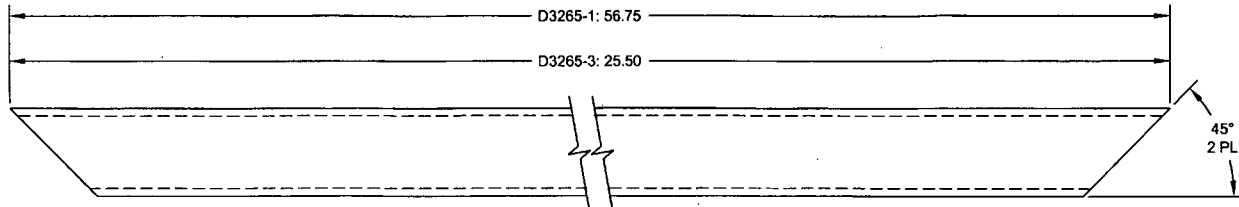
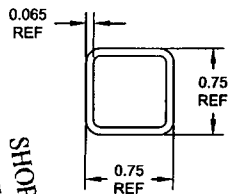
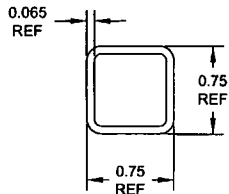
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

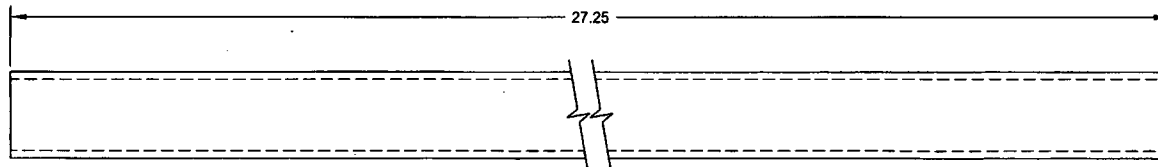
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A -	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3265-1 RIB

D3265-3 RIB



D3265-5 RIB

**DEO ATTACHED
RELEASED**
08.09.14

NOTES:

- 1) FRAME MATERIAL: SEE SHEET 1
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RL	DRAWING NO.	REV. C
MFG. APPR.	RL	D3265	SHEET 4 OF 4
APPROVED	RL	TITLE	SCALE
DE APPR.	RL	BASKET BASE ASSEMBLY (350)	NTS
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DRAWING NO. D3265	TITLE BASKET BASE ASSEMBLY (350)	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3265-C-1	SHEET NO. SHEET 1 OF 2	SCALE NTS
DRAWN <i>[Signature]</i>	CHECKED <i>PH</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>		DE APPR. <i>[Signature]</i>		
DATE 09.04.16	DATE 09.04.16	DATE 09.04.16	DATE 09.04.16		DATE 09.04.16		

SHEET 1, MODIFY PARTS LIST AS FOLLOWS:

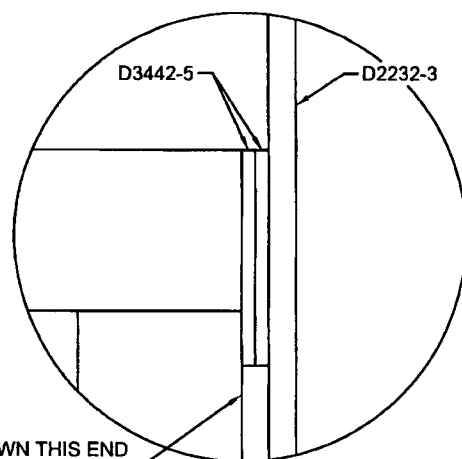
IS:

QTY -041	PART NUMBER	DESCRIPTION
X	D3265-041	BASKET ASSEMBLY
3	D2235-1	RIB
2	D3929-041	GUSSET ASSEMBLY
2	D3929-042	GUSSET ASSEMBLY
4	D3442-5	SHIM

WAS:

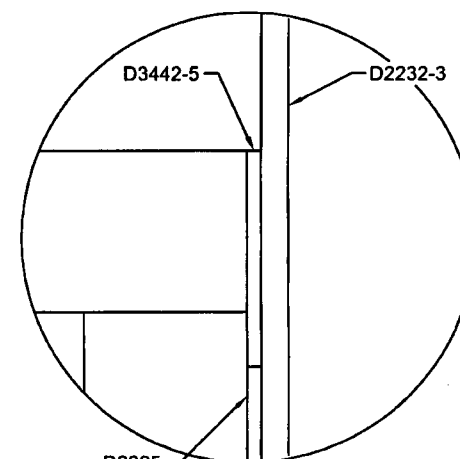
QTY -041	PART NUMBER	DESCRIPTION
X	D3265-041	BASKET ASSEMBLY
4	D2235-1	RIB
4	D2325	SUPPORT GUSSET
2	D3442-5	SHIM

SHEET 2, MODIFY DETAIL D AS SHOWN:



D3929-042 SHOWN THIS END
D3929-041 OPPOSITE END

DETAIL D C4-2
(BOTH ENDS)
SCALE 10X



DETAIL D C4-2
(BOTH ENDS)
SCALE 10X

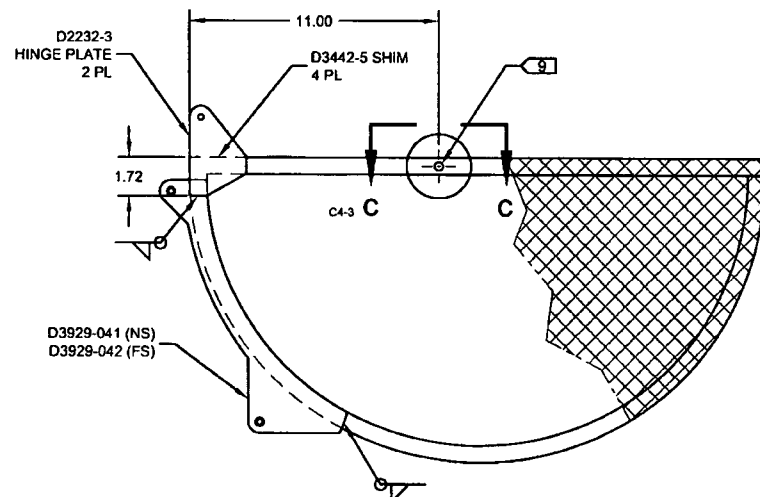
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01/04/22

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DRAWING NO. D3265	TITLE BASKET BASE ASSEMBLY (350)	REV. C	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D3265-C-1	SHEET NO. SHEET 2 OF 2	SCALE NTS
DRAWN <i>B</i>	CHECKED <i>AB</i>	MFG. APPR. <i>AB</i>	APPROVED <i>AB</i>	DE APPR. <i>AB</i>		
DATE 09.04.16	DATE 09.04.16	DATE 09/04/17	DATE 09.04.17	DATE 09.04.17		

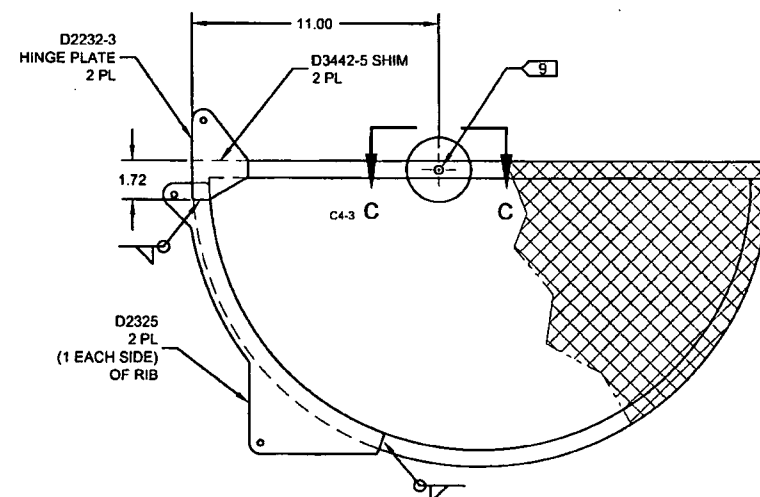
SHEET 3, MODIFY SECTION A-A AS SHOWN:

IS:



SECTION A-A A5-2
2 PL
(BOTH END RIBS)

WAS:



SECTION A-A A5-2
2 PL
(BOTH END RIBS)

RELEASED
09/04/17

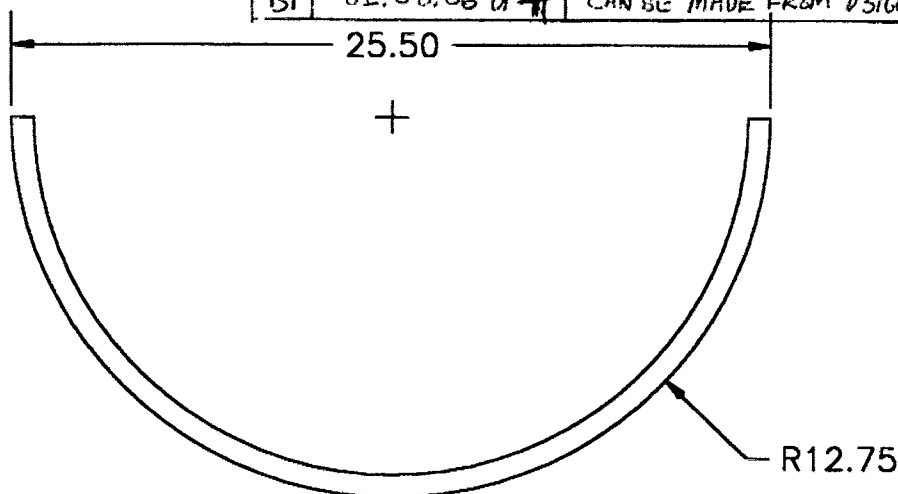
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WORK ORDER
NO. 283907



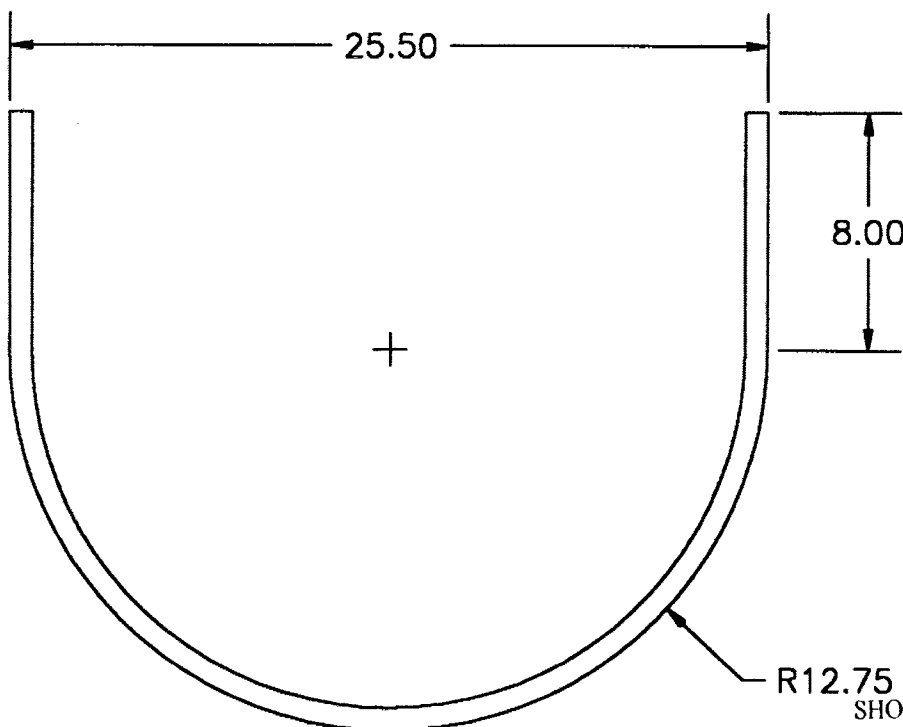
DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2235	REV. B SHEET 1 OF 1
DATE 94:12:16		TITLE BASKET RIBS	SCALE

BI 02.08.06 *[Signature]* CAN BE MADE FROM D3166-1

RELEASED
960507



D2235-1



D2235-3

CAN BE MADE FROM D3166-1 *[BI]*
MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL
CAN BE MADE FROM D3166-1

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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
SQR: *[Signature]*
WORK ORDER
NO. *[Signature]*